

IN THE CLAIMS:

1-4. (Cancelled

5. (Currently Amended) A method for molding an arm for an elastic doll,
comprising the steps of:

forming a molding space for molding a portion of the arm extending from a
shoulder thereof to a hand thereof in a mold;

arranging a metal core in said molding space so as to extend along a center of said
molding space, said core being fixed at one end thereof in a proximal section of said molding
space which corresponds to a proximal portion of the shoulder of the arm, said core being
provided at another distal end thereof or a portion thereof positioned in proximity to the another
distal end with a spacer for keeping said core spaced at a predetermined radial interval from an
annular inner surface of said molding space, and the distal end of the metal core is spaced in a
lengthwise direction from a distal end of the molding space adjacent the molding space which
corresponds to a hand of the arm; and

injecting a molten molding material into said molding space at a molding
temperature to melt the spacer so that the spacer becomes integral with the molten molding
material;

said spacer being made of a synthetic resin material which is compatible with said
molding material and has a melting point equal to or below the molding temperature of said
molding material.

6. (Currently Amended) A method for molding arms for an elastic doll, comprising the steps of:

forming a pair of molding spaces for molding portions of arms, each, extending from a shoulder of an arm to a hand thereof in a mold including mold members, said molding spaces being formed opposite to each other to permit proximal sections thereof which respectively correspond to proximal portions of the shoulder of each of the arms to face each other;

arranging a metal core in said molding spaces so as to continuously extend along a center of said molding spaces; said metal core being provided at each of distal ends thereof or a portion thereof positioned in proximity to ~~an~~ the distal end with a non-movable spacer for keeping said metal core at a radial predetermined interval from the encircling inner surfaces of said molding spaces, the respective distal ends of each molding spaces is spaced from the distal ends of the molding spaces adjacent the molding spaces which correspond to a hand of the arm;
~~and~~

injecting a molten molding material into said molding spaces at a molding temperature to melt the spacer;

said metal core being ~~formed~~ fixed at an exterior portion thereof positioned between said molding spaces with a bent section;

said mold members having respective mating surfaces, one of which is formed thereon with projections engaged with said bent section of said metal core and opposite sides of said metal core to stationarily hold said metal core;

22 said spacer being made of a synthetic resin material which is compatible with said
23 molding material and has a melting point equal to or below the molding temperature of said
24 molding material;

25 melting the spacer to integrate the spacer material with the molding material;
26 removing the pair of molded arms from the molding spaces; and
27 removing the bent section of the metal core to disconnect the molded arms from
28 each other.

1 7. (Previously Presented) A method for molding arms for an elastic doll, comprising
2 the steps of:

3 forming a pair of molding spaces for molding portions of arms, each extending
4 from a shoulder of an arm to a hand thereof in a mold including mold members, said molding
5 spaces being formed opposite to each other to permit proximal sections thereof which
6 respectively correspond to proximal portions of each shoulder of each of the arms to face each
7 other;

8 providing a single metal core of a laterally symmetric configuration;

9 attaching a pair of spacers of a synthetic resin material to the metal core, each
10 respective spacer is affixed adjacent an end of the metal core in a non-movable manner;

11 arranging said metal core in said molding spaces so as to continuously extend
12 along a center of said molding spaces while keeping both side portions of said core respectively
13 projected into said molding spaces, with the assistance of said spaces;

14 securing a portion of said metal core at a location between said pair of molding
15 spaces;

16 joining said molding members of said mold to each other so as to hold said metal
17 core fixed on mating surfaces of said mold members to keep both sides of said core floated in
18 said molding spaces;

19 injecting a molten molding material into said molding spaces, the synthetic resin
20 material is compatible with said molding material and has a melting point equal to or below a
21 molding temperature of said molding material, said spacers of a size and configuration not to
22 move by an injection pressure during the injection of the molding material and to subsequently
23 melt and become integral with the molding material;

24 permitting the arms to form; and

25 cutting said metal core at an intermediate position between the formed arms.

1 8. (Previously Presented) A method for molding an arm for an elastic doll,
2 comprising the steps of:

3 forming a molding space for molding a portion of the arm extending from a
4 shoulder of the arm to a hand thereof in a mold, the shoulder of the arm being provided with an
5 engagement groove adapted to be engaged with a trunk of a doll;

6 arranging a metal core in said molding space so as to extend along a center of said
7 molding space and holding said core at a predetermined position in said molding space by a
8 holding means;

9 arranging a support rod at a site in said molding space corresponding to said
10 engagement groove, said support rod functioning to support said core against an injection
11 pressure of a molding material during molding of the arm; and

12 injecting a molding material into said molding space.

1 9. (Previously Presented) A method for molding an arm or arms for an elastic doll
2 as defined in claim 5, wherein the shoulder of the arm is provided with an engagement groove
3 adapted to be engaged with a trunk of a doll;

4 further comprising the step of arranging a support rod at a site in said molding
5 space corresponding to said engagement groove, said support rod functioning to support said
6 core against an injection pressure of a molding material during molding of the arm.

1 10. (Previously Presented) A method for molding arms for an elastic doll as defined
2 in claim 6, further comprising the steps of:

3 separating said mold members from each other after molding of the arms; and

4 removing a portion of the core exposed from the shoulder of each of the arms.

1 11-18. (Cancelled)

1 19. (Previously Presented) A method for molding arms for an elastic doll as defined
2 in claim 6, wherein the shoulder of each arm is provided with an engagement groove adapted to
3 be engaged with a trunk of a doll;

4 further comprising the step of arranging a support rod at a site in each molding
5 space corresponding to said engagement groove, said support rod functioning to support said
6 core against an injection pressure of a molding material during molding of the arm.

1 20. (Previously Presented) A method for molding arms for an elastic doll as defined
2 in claim 7, further comprising the steps of:

3 separating said mold members from each other after molding of the arms; and

4 removing a portion of the core exposed from the shoulder of each of the arms.

1 21-23. (Cancelled)

1 24. (New) The method for molding an arm for an elastic doll in claim 5, further
2 comprising the steps of:

3 providing a polyethylene spacer to encircle the metal core, the spacer having
4 radial projections to space the metal core from encircling surfaces of the molding space.

1 25. (New) The method for molding an arm for an elastic doll in claim 24, further
2 comprising the steps of injecting a thermoplastic elastomer molding material having a melting
3 point in a range of 100°C to 170°C.

1 26. (New) A method for molding an arm for an elastic doll, comprising the steps of:
2 forming a molding space for molding a portion of the arm extending from a
3 shoulder thereof to a hand thereof in a mold;

4 arranging a metal core in said molding space, said metal core being fixed at one
5 end thereof in a proximal section of said molding space which corresponds to a proximal portion
6 of the shoulder of the arm;

7 attaching an annular synthetic resin spacer to encircle the metal core and position
8 the metal core at the center of said molding space, the annular spacer has a plurality of
9 projections that extend radially outward from the metal core on at least four sides, said metal
10 core being provided at another end thereof or a portion thereof positioned in proximity to the
11 another end with the spacer for keeping said metal core spaced at a predetermined interval from
12 an inner surface of said molding space; and

13 injecting a molten thermoplastic elastomer molding material having a melting
14 point in a range of 100°C to 170°C into said molding space at a molding temperature to melt the
15 spacer so that the spacer becomes integral with the molten molding material;
16 said spacer being made of a synthetic resin material which is compatible with said
17 molding material and has a melting point below the molding temperature of said molding
18 material.

1 27. (New) The method for molding an arm for an elastic doll as defined in claim 26,
2 further comprising the steps of:
3 providing a spacer of polyethylene.

1 28. (New) The method for molding an arm for an elastic doll as defined in claim 27,
2 further comprising providing a spacer with four equally spaced comical projections.

1 29. (New) The method for molding an arm for an elastic doll as defined in claim 26,
2 further comprising extending the metal core out of the molding space at one end and holding the
3 extended metal core during the injection of molten thermoplastic elastomer molding material.